

Work Order ID 69611

Thursday, May 12, 2011 3:33:57 PM



Page 1

Item ID: D3953-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Gas Spring Stud, Lid

Start Date: 5/12/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: 

Date: 11-05-12 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3953

C

0.00

100




Doosan

Doosan Lathe

Memo

Turn as per folio FA852 & DWG

FOLIO REV: DWG REV: 

0.00

20 11.5.19

20

DEBURR

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

20 11.5.19

20

Memo

0.00

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69611

Thursday, May 12, 2011 3:33:57 PM

Page 2

Item ID: D3953-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Gas Spring Stud, Lid

Start Date: 5/12/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 20.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>✓</i>	<i>11/5/20</i>		<i>10</i>			
130  Packaging Packaging	Identify as per dwg & Stock Location: <i>096</i> Memo	0.00 0.00							<i>11/5/24</i> <i>(20)</i>
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>11/5/24</i> <i>MF</i> <i>11-05-24</i>

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

Thursday, May 12, 2011 3:34:05 PM

Page 1

Work Order ID: 69611

Parent Item: D3953-3

Parent Item Name: Gas Spring Stud, Lid



Start Date: 5/12/2011

Required Date: 5/24/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevA: New issue DD verified by:EC,
per dwg revC DD 10.03.02 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304RO.750

Purchased

No

100

f

102.2870

0.125

2.631579



20 11.5.19

304 SS Roundbar .750

Location

Loc Qty

Loc Code

MAT028

42.287

116501

18.207

116623

24.08

MAT029

60

117481

60

2.5

W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 69611
Description: Gas Spring Stud, Lid		Part Number: D3953-3
Inspection Dwg: D3953	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.75	+/-0.030	.749	/		20.02	
0.56	+/-0.010	.557	/			
0.281	+/-0.010	.281	/			
1/4-28 UNF-2A	N/A	2A	/			
Major Ø	Max = 0.2490 Min = 0.2425	.246	/		20.06	
M.O.W.	Max = 0.26687 Min = 0.26357	.265	/		"	
Ø0.098	+0.004/-0.001	.098	/		20.02	
Ø0.250	+/-0.010	.246	/			
0.170	+/-0.010	.170	/			
0.330	+/-0.010	.330	/			
0.13	+/-0.030	.131	/			
R0.06	+/-0.030	2.060	/			
1.31	+/-0.030	1.316	/			

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11.5.19	Date: 11/5/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	09.12.14	Dwg Rev updated	KJ	[Signature]

W/O:		WORK ORDER CHANGES						
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

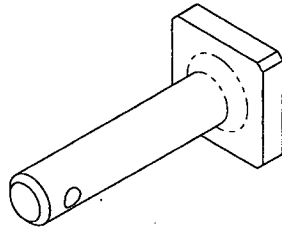
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NOTE: Date & initial all entries

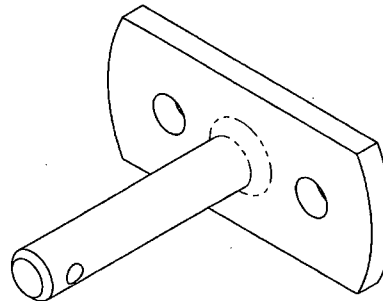
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69611
2011-05-12



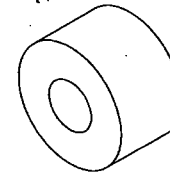
D3953-1 GAS SPRING BRACKET
(FULL LID)



D3953-3 GAS SPRING STUD, LID



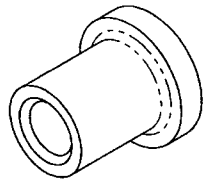
D3953-5 GAS SPRING STUD, BASE



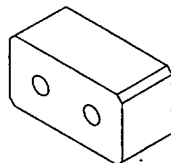
D3953-7 GAS SPRING SPACER



D3953-9 GAS SPRING WASHER



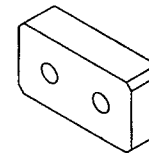
D3953-11 GAS SPRING SPACER



D3953-13 GAS SPRING SPACER
(FULL LID)



D3953-15 GAS SPRING BRACKET
(SPLIT LID)

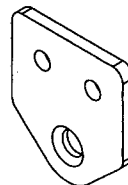


D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)

RELEASED
2010-02-26



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)

C	PARTS -19 & -21 ADDED (SHT 18 & 4); CSK CALLOUT WAS CHAM (C6-2, B6-3, C6-4); C SYMM WAS C SYM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REQD, DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1 DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED. REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

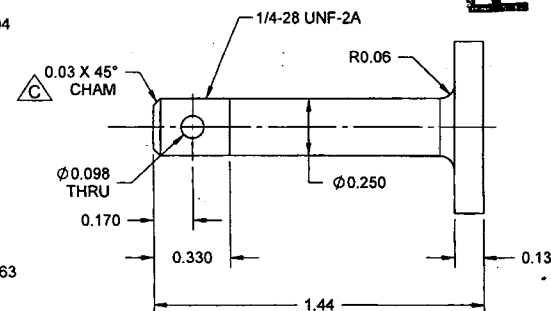
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT
-1: 0.11 lbs
-3: 0.03 lbs
-5: 0.06 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3953 TITLE GAS SPRING LID COMPONENTS COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. C
DRAWN	JPH		SHEET 2 OF 4
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.01.29		

2010-02-26
RELEASED

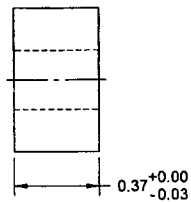
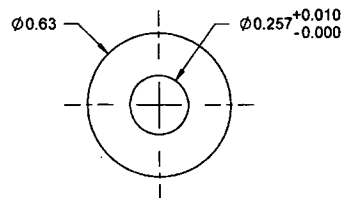
W/O:		WORK ORDER CHANGES						
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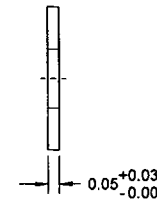
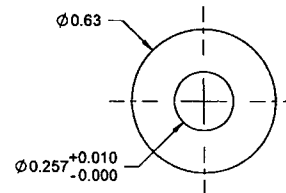
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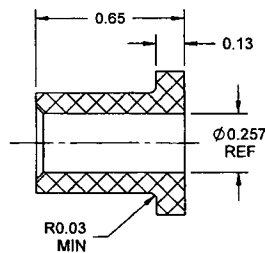
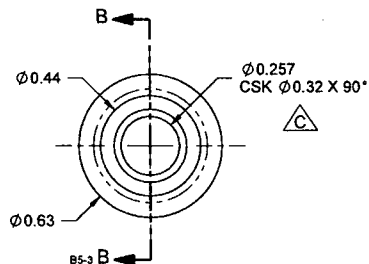
NOTE: Date & initial all entries



D3953-7 GAS SPRING SPACER

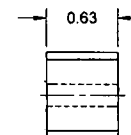
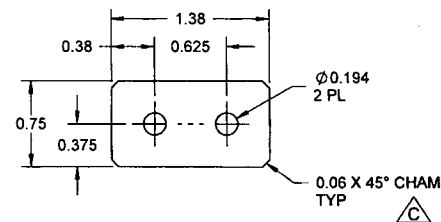


D3953-9 GAS SPRING WASHER



D3953-11 GAS SPRING SPACER

SECTION B-B B7-3



D3953-13 GAS SPRING SPACER

NOTES:

1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELIRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -7/-9/-11: < 0.01 lbs EACH
-13: 0.17 lbs

u/b 09/01/11

RELEASED
2010-02-26

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DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV: C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
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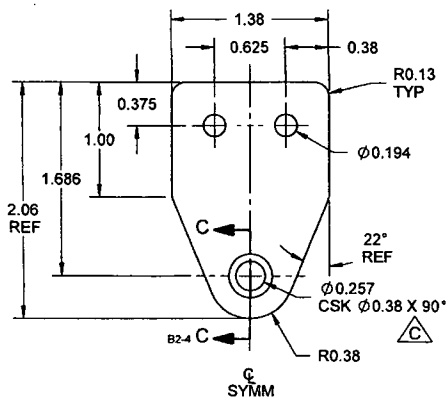
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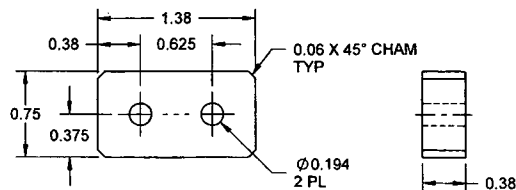
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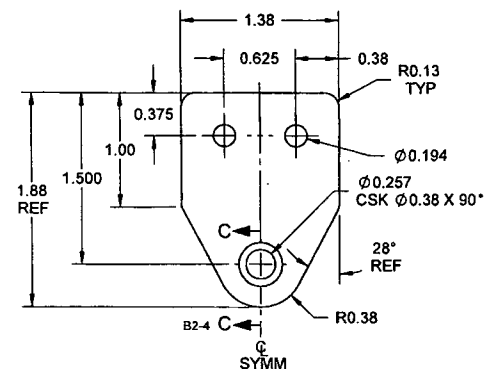
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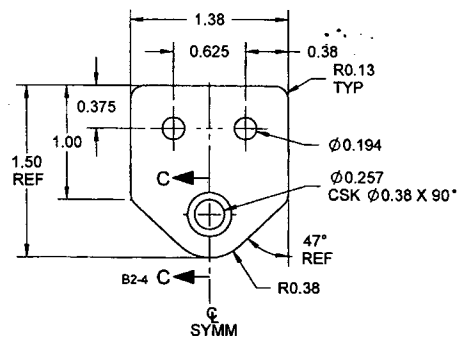
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



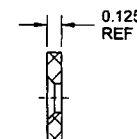
D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)



SECTION C-C

NOTES:
1) MATERIAL -15/-19/-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA

-17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -15: 0.08 lbs
-17: 0.10 lbs
-19: 0.07 lbs
-21: 0.06 lbs

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	AJS	DRAWING NO.	REV. C
DRAWN	JPH	D3953	SHEET 4 OF 4
CHECKED		TITLE	SCALE
MFG. APPR.		GAS SPRING LID COMPONENTS	NTS
APPROVED			
DE APPR.			
DATE	10.01.29		

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